

# Work Order ID 60283

Thursday, July 01, 2010 10:17:10 AM



Page 1

Item ID: D2281

Accept



Setup Start



Revision ID:

Item Name: Jack Saddle

Stop



Start Date: 7/2/2010 Start Qty: 110.00



Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 110.00



Customer:

Reference:

Approvals:

Process Plan: MC

Date: 10-7-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2281	Rev G								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281 ☐ Dwg Rev: G ☐ Prog Rev: G ☐ 2-  
Deburr if necessary

304.080

RB 10-7-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 10-7-22

120 108  
118

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.10.10.104

counter  
1116  
108

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Start Date: 7/2/2010 Start Qty: 110.00



Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 110.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

0.00

Small Fab

Memo  
Debur

0.00

w/105

140



Brake NC

NC BRAKE

0.00

Brake NC

Memo

Form as per D2281 using D2281-T2

0.00

8B 12/08/05

108

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

810108/05

count

4108

Quality Control

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Accept



Setup Start



Revision ID:

Stop



Item Name: Jack Saddle

Start Date: 7/2/2010 Start Qty: 110.00



Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 110.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

*EL 10-8-24 (X108)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/08/25*  
*CL10/8/25*

# Picklist Print

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Page 1

Work Order ID: 60283



Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 7/2/2010

Required Date: 9/3/2010

Start Qty: 110.00

Required Qty: 110.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM  
IPP: rev B ☐ 06.07.17 ☐ waterjet ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

100

sf

128.0608

0.125

14.47368

15.



304SS sheet .080



RB 10-7-22

Location

Loc Qty

Loc Code

MAT20

128.0608

113295

128.0608

113295

120

118

DART AEROSPACE LTD		Work Order:	60283
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.476	✓		HB-02 vern	
4.114	+/-0.010	4.118	✓		vern	
2.933	+/-0.010	2.935	✓		"	
1.535	+/-0.010	1.536	✓		"	
0.354	+/-0.010	0.353	✓		"	
0.354	+/-0.010	0.354	✓		"	
0.604	+/-0.010	0.604	✓		"	
2.000	+/-0.010	1.999	✓		"	
3.396	+/-0.010	3.396	✓		"	
3.646	+/-0.010	3.646	✓		"	
4.000	+/-0.010	4.008	✓		"	
1.525	+/-0.010	1.530	✓		"	
2.475	+/-0.010	2.477	✓		"	
Ø0.323	+0.006/-0.001	0.324	✓		"	
0.080	+/-0.010	0.074	✓		"	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-7-02	Date: 10/08/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

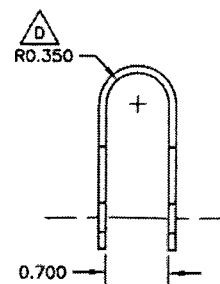
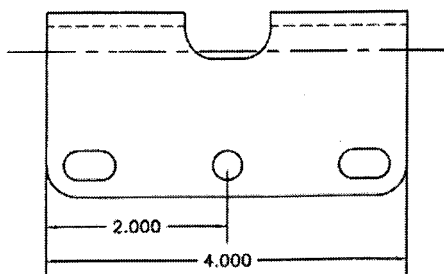
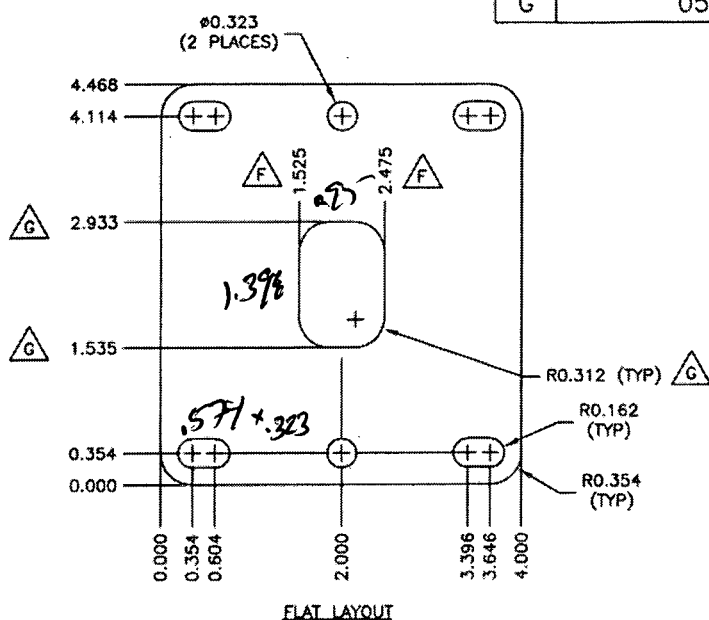
**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11



#### D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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